

D4781-1 DOUBLER

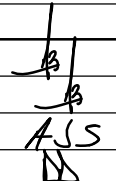
D4781-5 DOUBLER

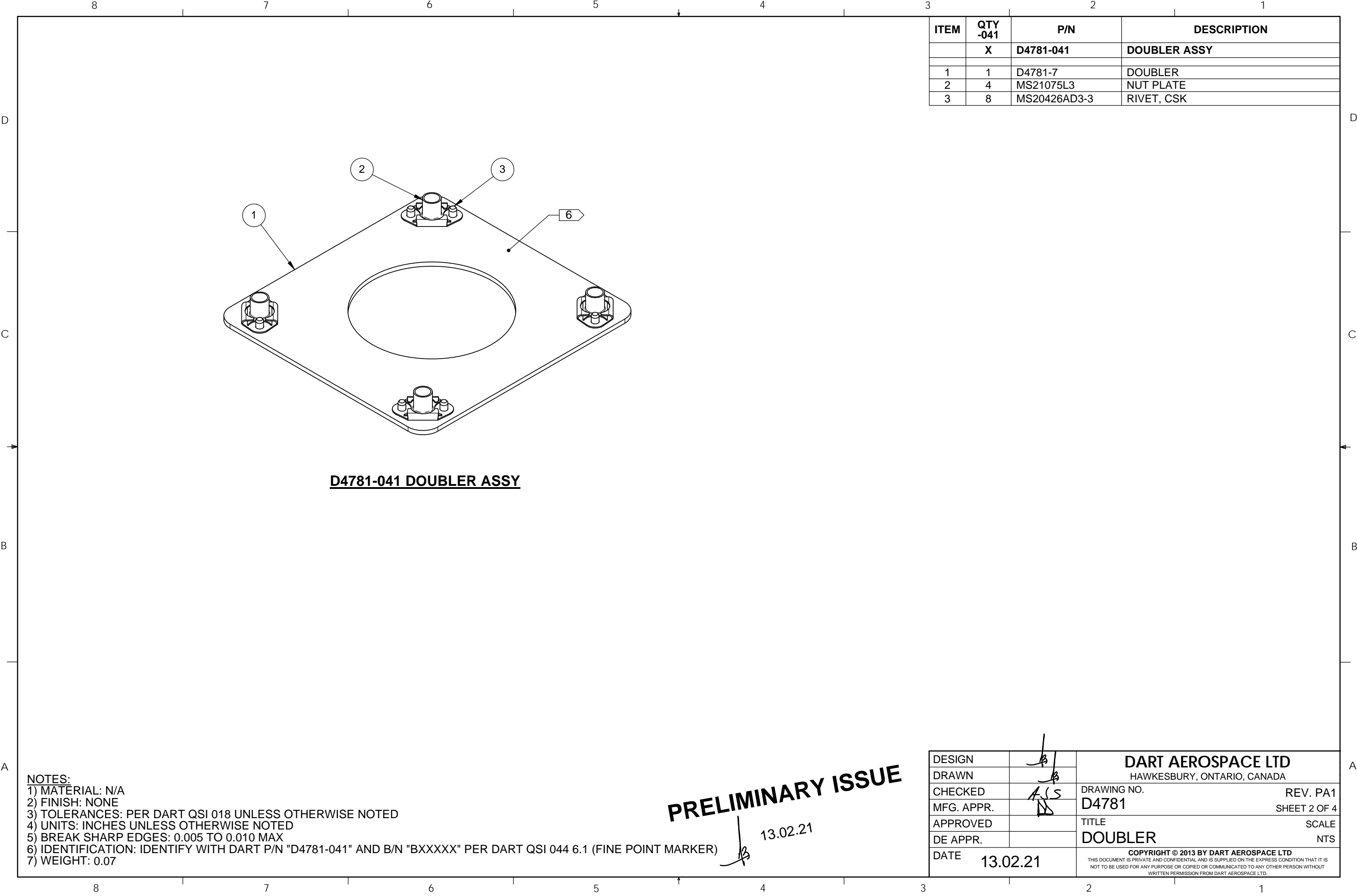
D4781-3 DOUBLER

D4781-041 DOUBLER ASSY

PRELIMINARY ISSUE

13.02.21

PA1	NEW ISSUE		MB	13.02.21
REV.	DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO.	REV. PA1	
MFG. APPR.		D4781	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.	DOUBLER	NTS		
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



ITEM	QTY -041	P/N	DESCRIPTION
	X	D4781-041	DOUBLER ASSY
1	1	D4781-7	DOUBLER
2	4	MS21075L3	NUT PLATE
3	8	MS20426AD3-3	RIVET, CSK

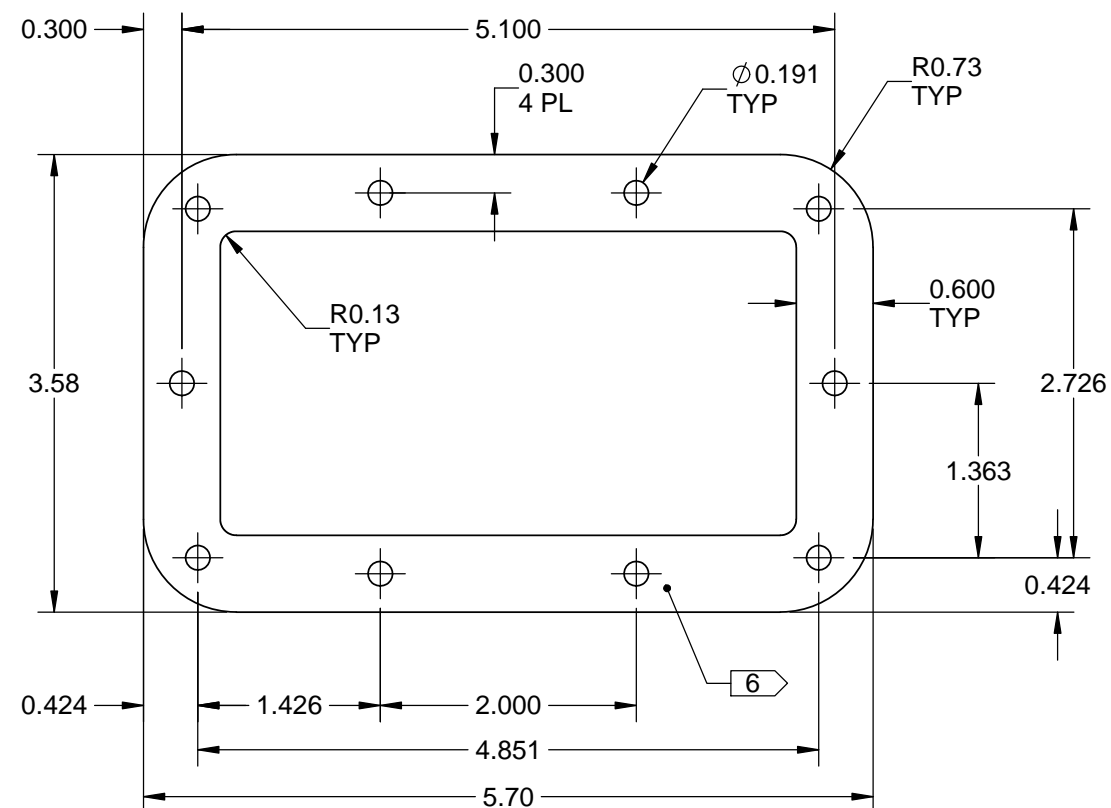
D4781-041 DOUBLER ASSY

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4781-041" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
7) WEIGHT: 0.07

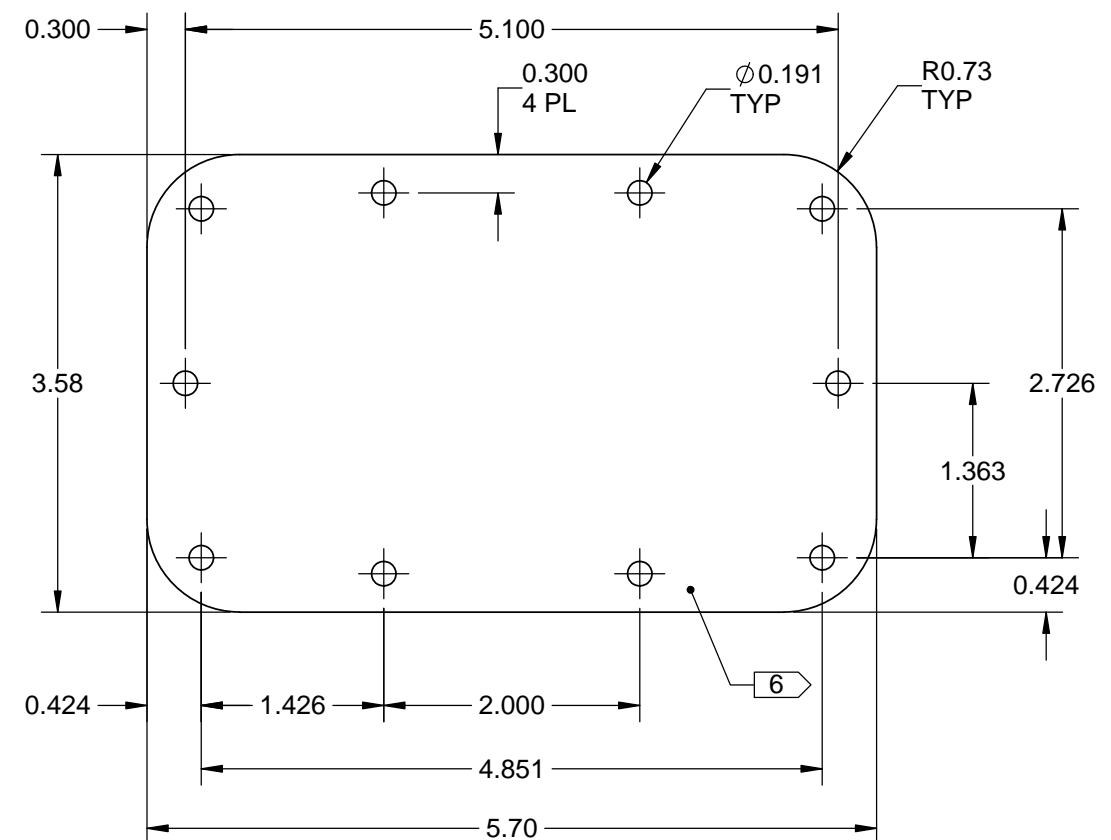
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DRAWN			
CHECKED		DRAWING NO. D4781	REV. PA1
MFG. APPR.		SHEET 2 OF 4	
APPROVED		TITLE DOUBLER	SCALE NTS
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D4781-1 DOUBLER






D4781-3 DOUBLER

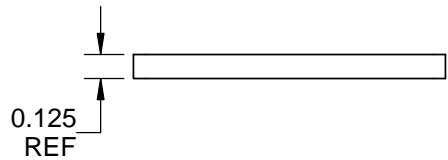
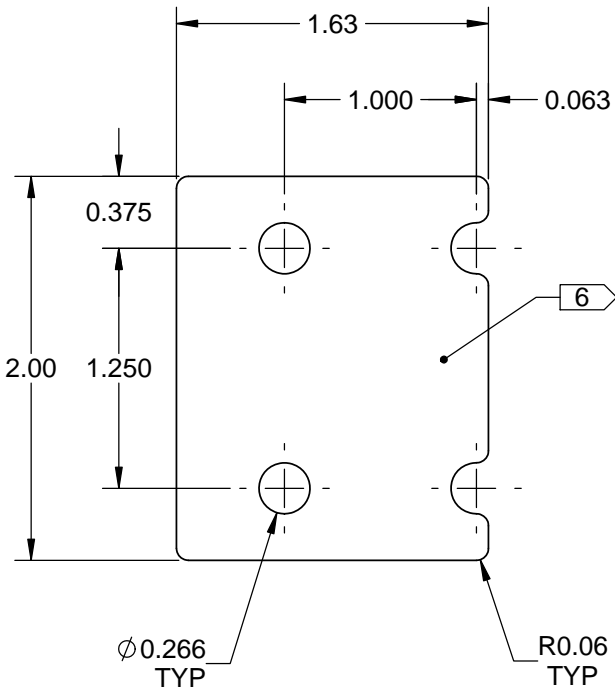
NOTES:

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.063 THICK PER
QQ-A-250/3 OR AMS QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4781-X" AND B/N "BXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER)
 - 7) WEIGHT: D4781-1 = 0.05 lbs; D4781-3 = 0.13 lbs

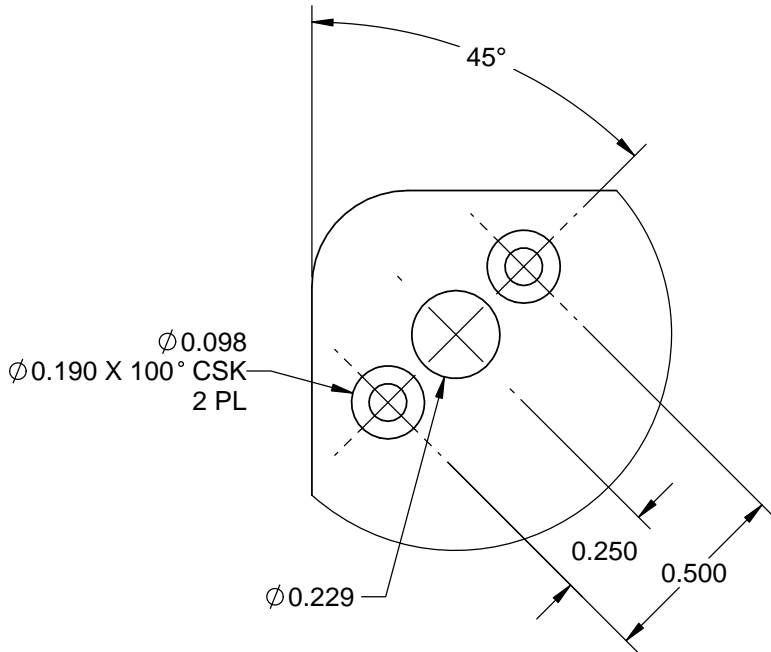
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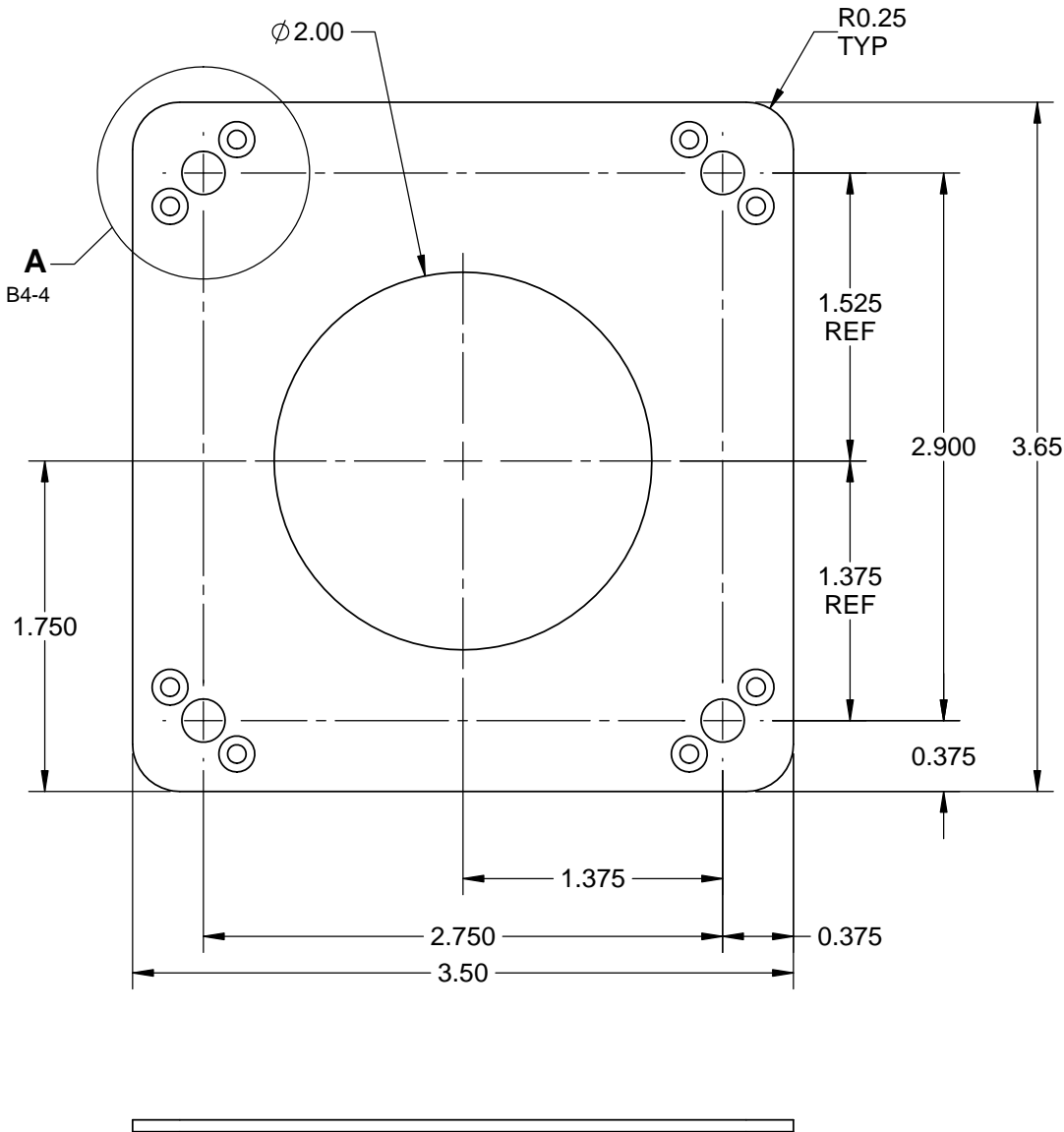
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4781	SHEET 3 OF 4
APPROVED		TITLE	SCALE
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D4781-5 DOUBLER



DETAIL A D4-4
4 PL, SCALE 2X



D4781-7 DOUBLER

NOTES:

- 1) MATERIAL: -5: 6061-T6/T62 ALUMINUM SHEET 0.125 THICK PER QQ-A-250/3 OR AMS QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF DART SPEC M6061T6S.125
-7: 6061-T6/T62 ALUMINUM SHEET 0.063 THICK PER QQ-A-250/3 OR AMS QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4781-5" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: D4781-5 = 0.04 lbs; D4781-7 = 0.06 lbs

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